

Procedure: First measure inside of foot in front of base, this should be $4\frac{1}{2}$ ". If different, adjust tank width accordingly. Cut out and weld tank. Weld or braze inlet and outlet fittings. Filler cap may be made from $\frac{3}{8}$ " union, remove nut and discard the piece in it. Turn a piece of steel that will fill the hole and rest on the shoulder of the nut. Braze on the outside. Threaded half of union should be installed on $4\frac{1}{2}$ " nipple and screwed into tank. Mount tank in base with 10-32 screws tapped into edge of foot. Locate and drill front of base for fuel line.

Step 19

MUFFLER: Sheet #10

Part: #153

Materials: 3" dia. x $1\frac{1}{8}$ " CRS. and bottom from large spray can.

Procedure: Turn body from 3" dia. or fabricate. Remove bottom from empty spray can (over $2\frac{1}{2}$ ") with can opener. Flatten outer edge, trim to size and install.

Step 20

CRANK GUARD: Sheet #11

Part: #157

Material: $\frac{1}{8}$ " x 3" x 9" CRS.

Procedure: Bend using drawing as template.

Step 21

ASSEMBLY: Sheet #11

- a. Fit main bearings ($1\frac{1}{8}$ " O.D. x $\frac{7}{8}$ " I.D. x 1" long bushings and spacer #109) on crankshaft and install in main bearing block. Hand scrape bearings as necessary.
- b. Install camgear #111 on camshaft #134. With hub away from housing, drill and halfdog.
- c. Install $\frac{5}{8}$ " O.D. x $\frac{1}{2}$ " I.D. x 1" long bronze bushing in camshaft housing #106. Drill oil hole from top of housing.
(assembly continued on next page)